

Stock

Work Order ID 140612

140612

Page 1

Item ID: D4095-047

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearpad Aft

Start Date: 1/11/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 1/25/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

SH

Date:

20160111

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4095	PC1 C								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.02							
FLOW CNC Waterjet	1-Cut as per Dwg (D4095-7) Dwg Rev: C Prog Rev: C 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89

JAN 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 140612***140612***

Page 2

January 11, 2016 10:54:44 AM

Item ID: D4095-047 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearpad Aft
Start Date: 1/11/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 1/25/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00			DAS 30 9-89	15			JAN 28 2016
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(15)			¹⁵ 9-89 JAN 28 2016
150 *150* autoweld 1 Automated Welding 1	Weld per dwg & QSI004 4.5 Large Fab Memo ***SEE NOTE 10 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: M133209	0.00 0.00				15/1/16	162-2		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 140612

January 11, 2016 10:54:44 AM

140612

Page 4

Item ID: D4095-047

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop ***NS2***

Item Name: Wearpad Aft

Start Date: 1/11/2016 Start Qty: 12.00

12

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Required Date: 1/25/2016 Req'd Qty: 12.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							DAS 38 0-99
190									
QC	Memo	0.00							
Quality Control									FEB 04 2016
200	Identify as per dwg & Stock Location: <u>FP-000</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging	LOCATION : FP001								
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.02							
Quality Control									

15XLS 1/18/2016

FEB 05 2016

MCS
1/18/2016MCS FEB 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Picklist Print

January 11, 2016 10:54:50 AM

Page 1

Work Order ID: 140612

140612

Parent Item: D4095-047

D4095-047

Parent Item Name: Wearpad Aft

Start Date: 1/11/2016

Required Date: 1/25/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP rev.A 11.11.07 new issue EC verified by:JLM
15.10.29 AUTOMATE WELDING DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No			sf	169.7000		1.764			

M304S16GA

304/316 Sheet .063

**

or 12/01/26

Location

Loc Qty

Loc Code

MAT019

169.7

m132797

2.45

m132835

7.25

m133511

160

2.4

ITEM	QTY -041	QTY -043	QTY -046	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-046	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD

D4095-041/-043/-046/-047/-049/-051 NOTES:

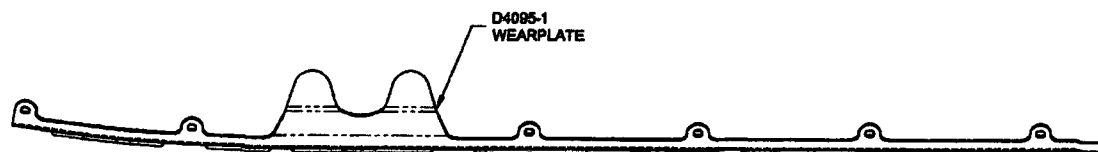
- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-00X" AND B/N "5X0000X" USING REMOVABLE TAG PER QSI 044 6.8
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-046 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT CENTERLINE

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EN 16-504

20160111

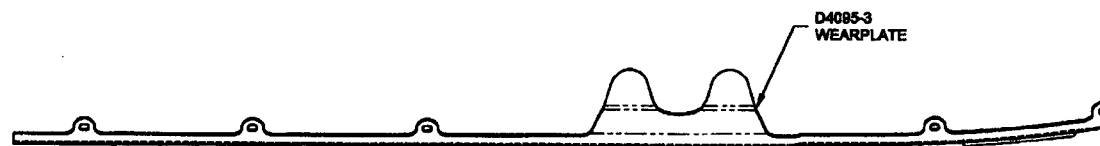
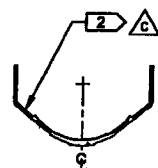
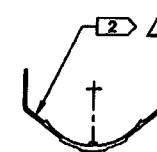
SH 140612

C	8259 WELD ROD WAS 20888, 0.20 WELD THICKNESS WAS 0.25, MOVE DRAIN HOLE IN -1/3, 0.9 WAS 2.00 (TYPE 84-8), ADJUST TOL. FOR MANUFACTURABILITY, NOTE 2 NOW REPS QSI 006 4.9, UPDATE MATL SPEC	CP	16.01.06
B	REVISED D4095-1/-1FR/3F; 4716 PLUS ONE ROCK-GUARD REPLACES D4095-1/-3; ADDED D4095-6/-7 -8/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.16
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE USA, INC		
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CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	BY	D4095	SHEET 1 OF 9
APPROVED	BY	TITLE	SCALE
DE APPR.	BY	WEARPLATE	NTS
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D4095-1
WEARPLATE

D4095-041 WEARPLATE ASSEMBLY



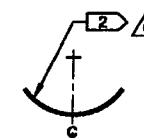
D4095-3
WEARPLATE

D4095-043 WEARPLATE ASSEMBLY



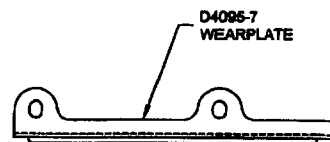
D4095-5
WEARPLATE

D4095-045 WEARPLATE ASSEMBLY

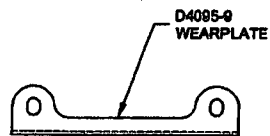
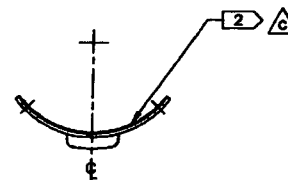


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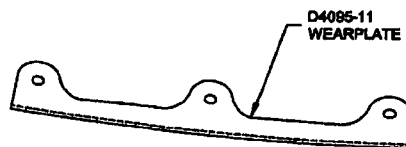
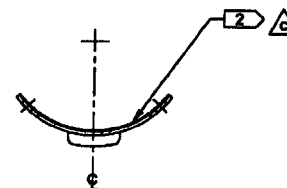
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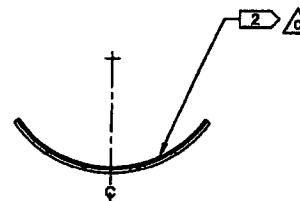
D4095-047 WEAR PAD ASSEMBLY



D4095-049 WEAR PAD ASSEMBLY

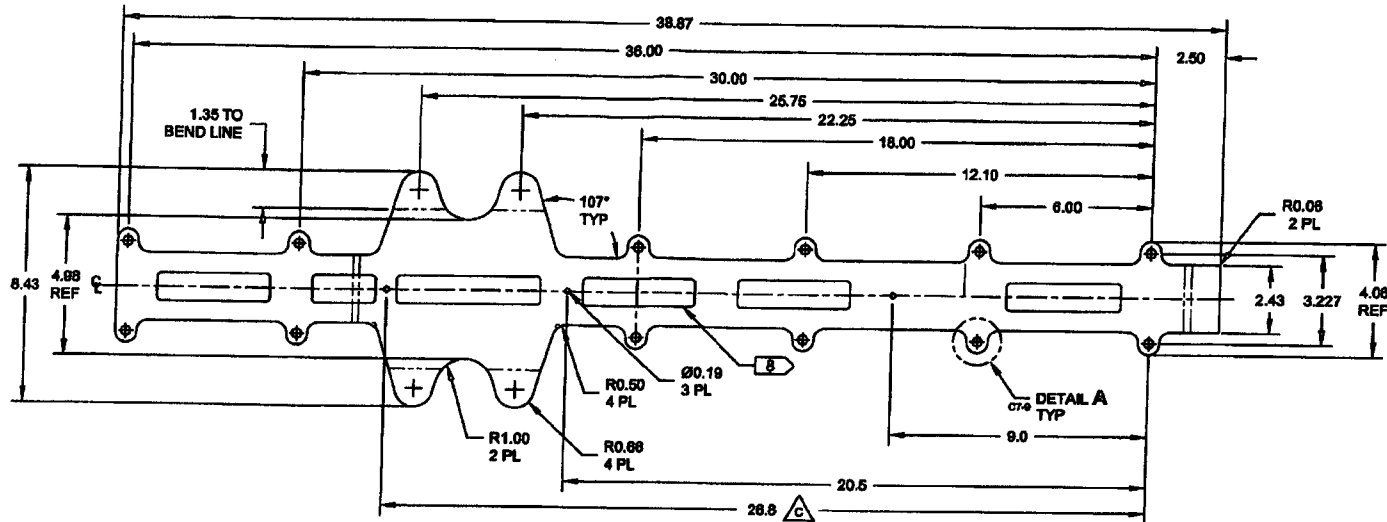


D4095-051 WEARPAD ASSEMBLY

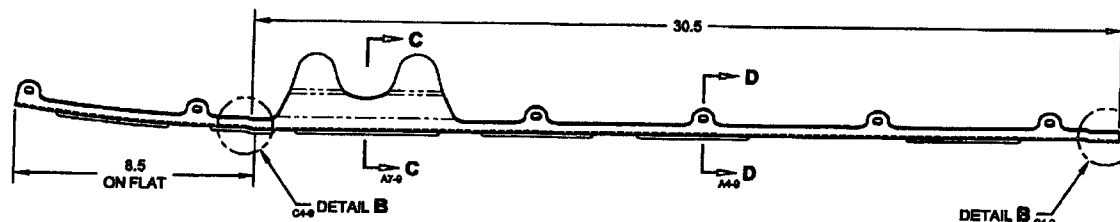


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APPROVED	<i>dy</i>	TITLE	SCALE
DE APPR.	<i>ST</i>	WEARPLATE	NTS
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D4095-1F FLAT PATTERN 1



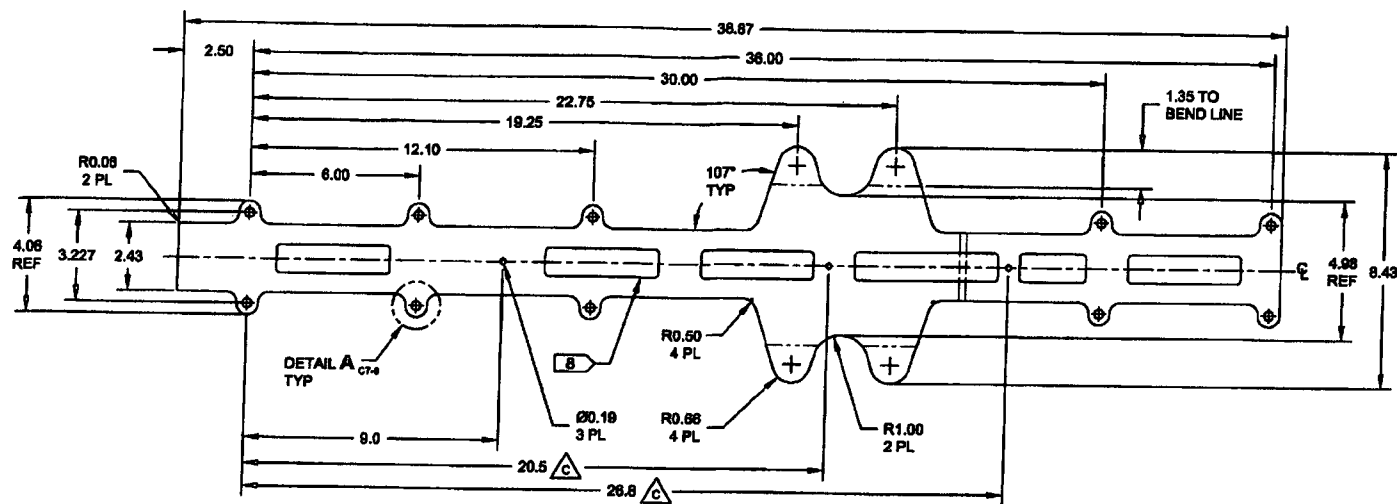
D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-1 NOTES:

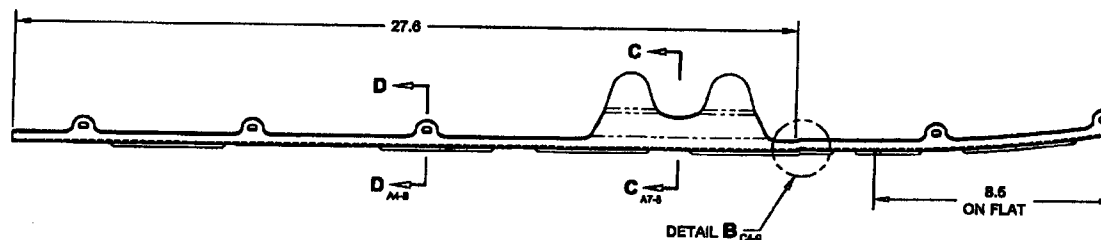
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 18 GAUGE (0.083 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240
OR ASME SA240 REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8269 ROD PER QSI 004 SECTION 4.5
- 9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

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APPROVED		TITLE WEARPLATE	SCALE NTS
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D4095-3F FLAT PATTERN (1)



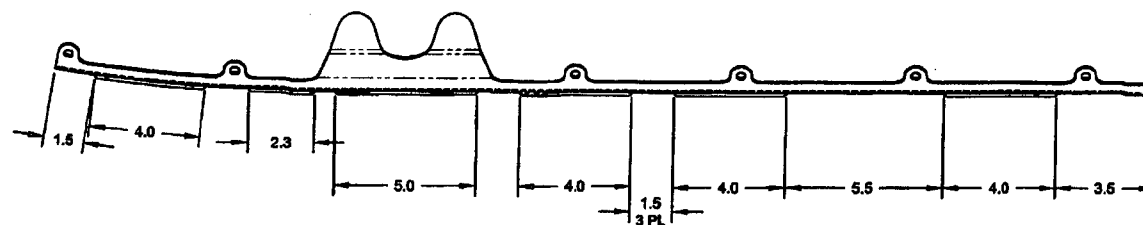
**D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)**

D4095-3 NOTES:

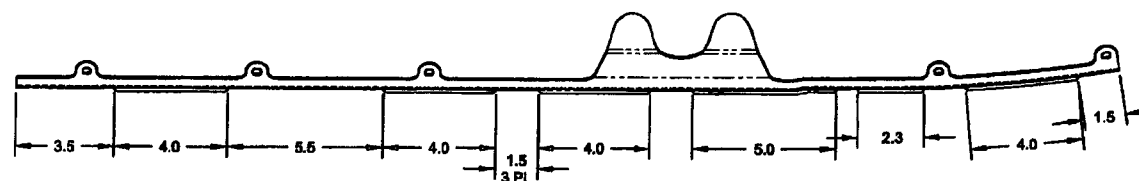
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 18 GAUGE (0.083 THICK) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240 REF DART MATERIAL SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8258 ROD PER QSI 004 SECTION 4.5
- 9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

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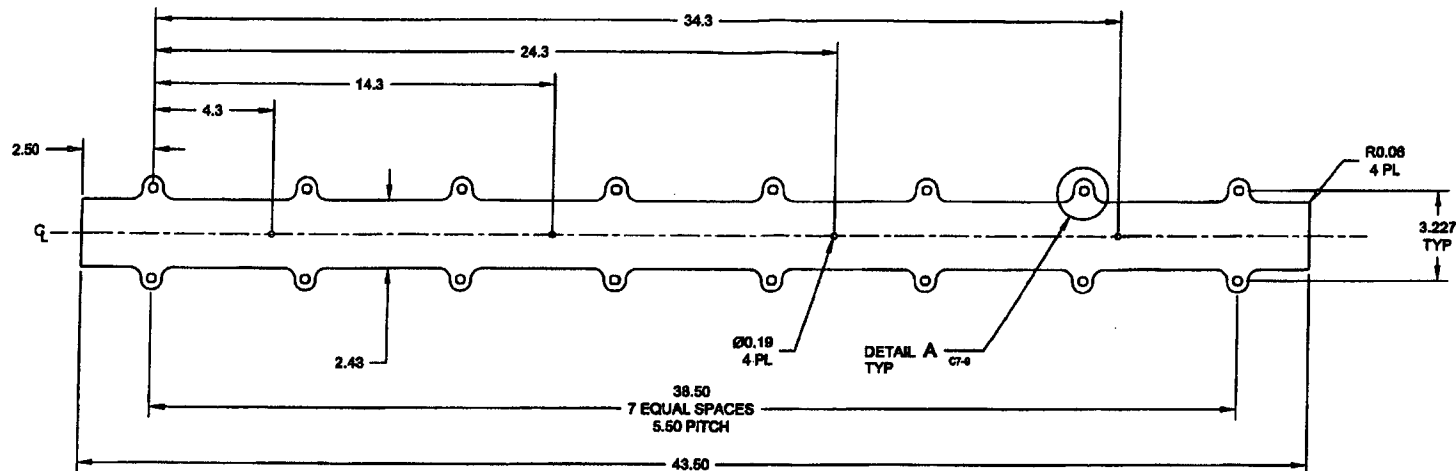
D4095-1 WELDING DETAIL



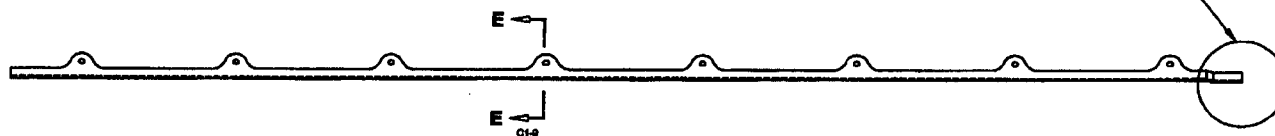
D4095-3 WELDING DETAIL

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D4095-5F FLAT PATTERN [1]



D4095-5 BENDING DETAIL
(MAKE FROM D4095-5F)

D4095-5 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240
OR ASME SA240 REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5
- 9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

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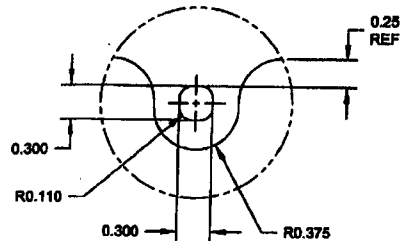
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4095	SHEET 7 OF 9
APPROVED		TITLE	SCALE
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9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

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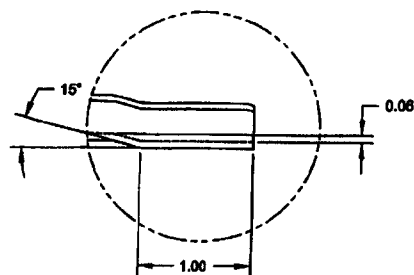
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DETAIL A: TAB DETAIL

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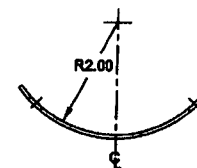
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03-9



DETAIL B: JOGGLE DETAIL

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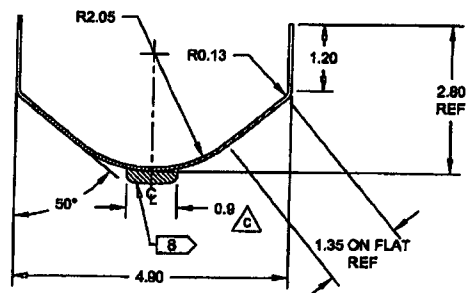
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03-7



SECTION E-E

SCALE 2X

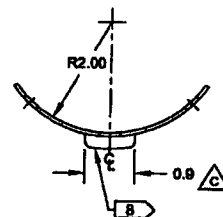
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SECTION C-C

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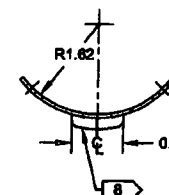
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03-4
03-4



SECTION D-D

SCALE 2X

03-4
03-4



SECTION F-F

SCALE 2X

03-4
03-4

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